



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4006-1
Job Sheet 195883



Part No: D4006-1

Job Qty: 4 pcs

Part Name: Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/31/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 6/14/19

Description:

Note: DWG REV B SHEETS 2,3 IPP rev A 09.12.18 new issue Prelim EC verified by:DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	4 pcs		6/14/19	0.17	0.25	Waterjet - Flow			DAS 69 6/27/19
120	QC 8	4 pcs		6/14/19	0.00	0.00	QC 8 - 12			DAS 40 9-89 JUN 27 2019 JUL 4 2019
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
							QC 8 - 47			
							QC 8 - 40			
							QC 8 - 52			
							QC 8 - 23			
							QC 8 - 57			
130	Small Fab - Brake NC - B4B	4 pcs		6/14/19	0.25	0.18	Small Fab - Brake - 1 - B4B			DAS 30 9-89 JUL 4 2019
							Small Fab - Brake - 2 - B4B			

Plex 5/31/19 1:20 PM Dart.lajeunesse.marie

				Small Fab - Brake - 3 - B4B	
140 QC 5	4 pcs	6/14/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 Handfinish - 1-1 Chemical-B4B	4 pcs	6/14/19	0.00 0.16	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 3	4 pcs	6/14/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	

DAS

JUL 24 2019

40
9-89

JUL 25 2019

DAS

JUL 25 2019

40
9-89

170 Packaging 3-1 - Stock - B4B	4 pcs	6/14/19	0.00 0.00	QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	JUL 26 2019
				QC 21 - SA - 53	DAS 70 9-89

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: P 2-Deburr if necessary
 Descriptions: 120 - QC8- Inspect parts - second check
 130 - (Bend/Assemble as per dwg)
 140 - QC5- Inspect part completeness to step on W/O
 150 - Chemical Conversion Coat per QSI005 4.1
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____ LOCATION : GA
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	4 sf (1 ea)	100-Waterjet - Flow - 1	5066326

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	4	149	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Angle	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter	
2	Angle	1.340Inches ± 0.030	1.370 1.310		
3	Angle	0.827Inches ± 0.010	0.837 0.817		
4	Angle	5.710Inches ± 0.030	5.740 5.680		
5	Angle	3.740Inches ± 0.030	3.770 3.710		
6	Angle	3.460Inches ± 0.030	3.490 3.430		
7	Angle	11.260Inches ± 0.030	11.290 11.230		
8	Angle	0.709Inches ± 0.010	0.719 0.699		
9	Angle	0.063Inches ± 0.010	0.073 0.053		

Plex 5/31/19 1:20 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 832-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S194549



Part: D4006-1

Job No: 195883

Serial No/Batch: S194549

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/27/19

H:/FORMS/CR